

Date: Thursday, 13/11/2008 1:06:31 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 350 SADDLE
<b>Job Number</b> : 43423	
<b>Estimate Number</b> : 12451	
<b>P.O. Number</b> :	<b>Part Number</b> : D35001
<b>This Issue</b> : 13/11/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3500 REV C
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : C
<b>Previous Run</b> : 43396	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 20/12/2008 <b>Qty:</b> 10 <sup>5</sup> <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLD 08.11.14</u>	
<b>Comment</b> : Est Rev:A New Issue 06-06-15 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6102013	Saddle Billet
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

6061-T6 7.0x6.5x2.0

350 Saddle Billet

Batch: B41962mk 08/11/18

⑤

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1Program Batch No. 43423 Double check by: DTP

1-Machine Step No 1 per Folio FA641 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA641 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA641 and inspect per attached Dimension Sheets

4-Deburr

5-Tumble to remove sharp edges.

mk 08/11/19

⑤

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINEmk 08/11/19

⑤

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK20 08/11/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief/Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 13/11/2008 1:06:31 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SADDLE

Job Number: 43423

Part Number: D35001

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

HL

08-11-20

(5)

6.0

POWDER COATING

POWDER COATING



M109152



(5X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:15  
320°F  
8:45

m-h 08/11/21

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

HL 08/11/24 (5)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

5432 HL 08/11/24 (5)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/26 JF

Job Completion



mc 08-11-24

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

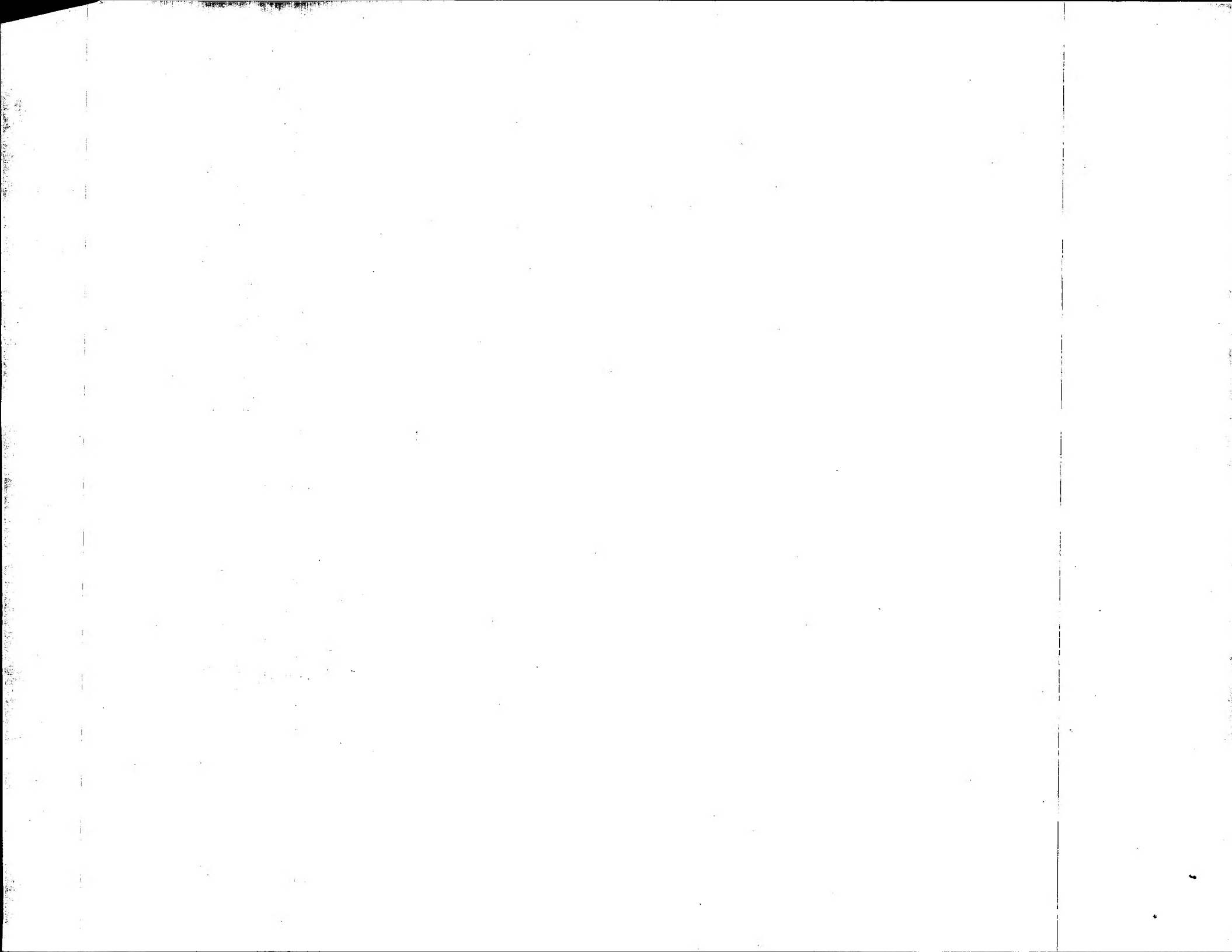
<b>DART AEROSPACE LTD</b>				<b>Work Order:</b> <u>LJ 3423</u>	
<b>Description:</b> Saddle				<b>Part Number:</b>	D3500-1
<b>Inspection Dwg:</b> D3500				<b>Rev:</b> C	
				<b>Page</b> 1 of 1	

				<b>Recorded Actual Dimensions</b>				<b>By</b>	<b>Date</b>
<b>Dim</b>	<b>Min</b>	<b>Max</b>	<b>Go/No Go Gauge</b>	<b>1</b>	<b>2</b>	<b>3</b>	<b>4</b>		
A	0.483	0.490		.487	.487	.487	.487		
B	1.175	1.185		1.178	1.180	1.180	1.179		
C	3.145	3.155		3.149	3.149	3.180	3.148		
D	1.175	1.185		1.178	1.180	1.180	1.179		
E	0.365	0.385		.371	.371	.372	.372		
F	0.490	0.510		.501	.499	.500	.502		
H									
I	R1.575	R1.595		1.587	1.586	1.586	1.586		
J	0.240	0.260		.241	.246	.246	.244		
K	0.490	0.510		.499	.499	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	<del>0.320</del>	322	.321	.321	.321	.321		
N	0.256	0.262		.258	.259	.259	.259		
O	6.500	6.520		6.505	6.505	6.505	6.505		
P	5.990	6.010		6.006	6.006	6.006	6.004		
Q	2.820	2.830		2.827	2.827	2.827	2.827		
R	2.495	2.505		2.499	2.499	2.500	2.500		
S	2.245	2.255		2.249	2.251	2.250	2.251		
T	1.120	1.130		1.122	1.124	1.127	1.124		
U	0.540	0.560		.555	.554	.557	.557		
V	0.793	0.803		.798	.798	.798	.799		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.132	1.131	1.131	1.131		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.630	.630	.630	.630		
AD	0.240	0.260		.256	.258	.257	.256		
AE	1.810	1.830		1.820	1.821	1.821	1.820		
AF	0.240	0.260		.251	.249	.251	.249		
AG	0.140	0.160		.152	.151	.151	.151		
AH	0.140	0.160		.158	.158	.159	.158		
AI	0.140	0.160		.153	.154	.152	.154		
<b>Accept/Reject</b>									

<b>Measured by:</b>	<u>gmy</u>
<b>Date:</b>	<u>08/11/19</u>

<b>Audited by:</b>	<u>R4</u>
<b>Date:</b>	<u>08/11/20</u>

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	<u>JD</u>



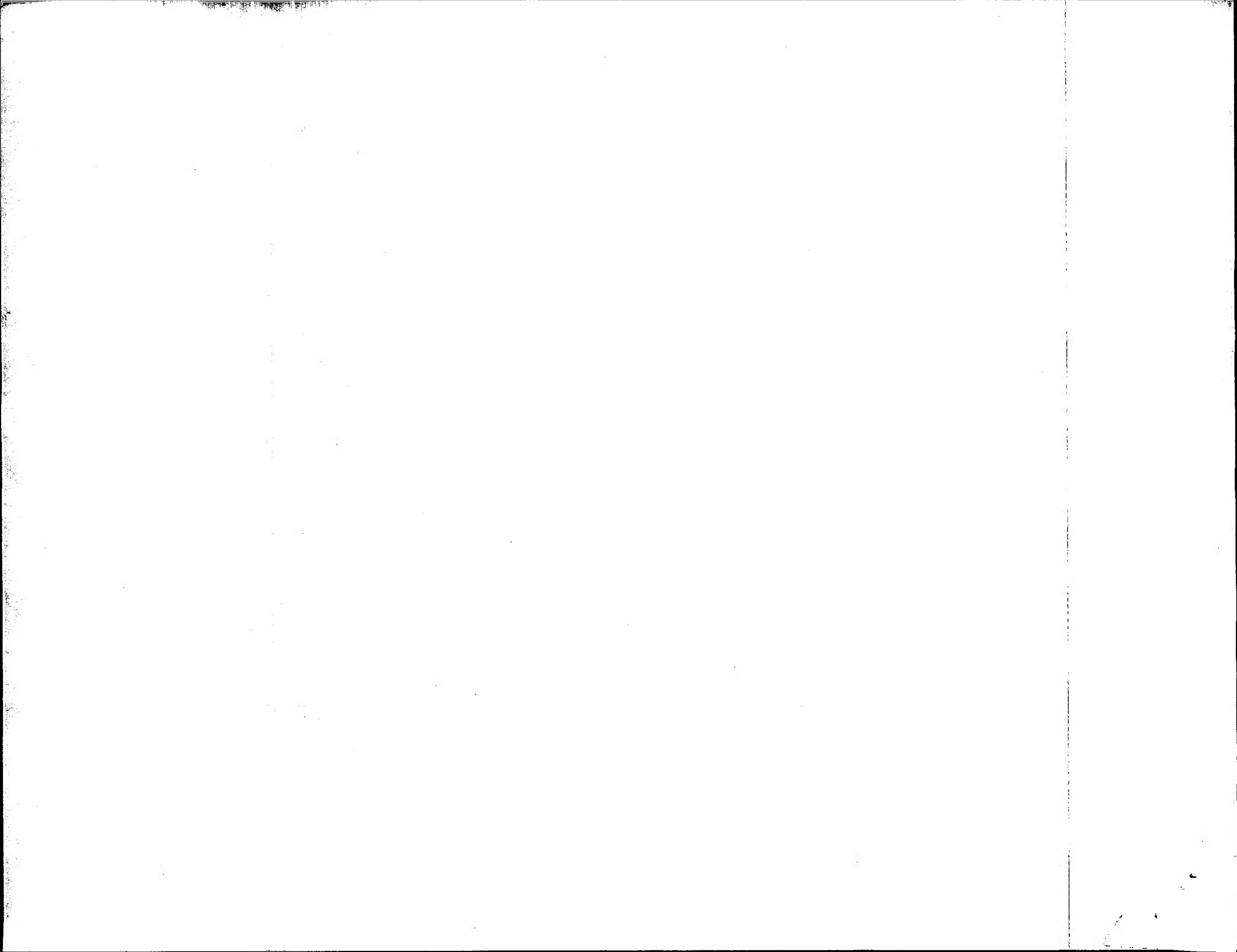
<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 43423
<b>Description:</b> Saddle		<b>Part Number:</b> D3500-1
<b>Inspection Dwg:</b> D3500	<b>Rev:</b> C	<b>Page 1 of 1</b>

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.487					
B	1.175	1.185		1.180					
C	3.145	3.155		3.150					
D	1.175	1.185		1.180					
E	0.365	0.385		.372					
F	0.490	0.510		.501					
H									
I	R1.575	R1.595		1.590					
J	0.240	0.260		.244					
K	0.490	0.510		.500					
L	3.590	3.650		3.620					
M	0.315	0.320		.321					
N	0.256	0.262		.258					
O	6.500	6.520		6.508					
P	5.990	6.010		6.005					
Q	2.820	2.830		2.827					
R	2.495	2.505		2.500					
S	2.245	2.255		2.250					
T	1.120	1.130		1.122					
U	0.540	0.560		.555					
V	0.793	0.803		.798					
W	R.240	R.260		.266					
X	0.040	0.060		.050					
Y	0.100	0.120		.110					
AA	R1.125	R1.145		1.131					
AB	R.490	R.510		.500					
AC	0.615	0.635		.630					
AD	0.240	0.260		.258					
AE	1.810	1.830		1.820					
AF	0.240	0.260		.250					
AG	0.140	0.160		.157					
AH	0.140	0.160		.158					
AI	0.140	0.160		.132					
Accept/Reject									

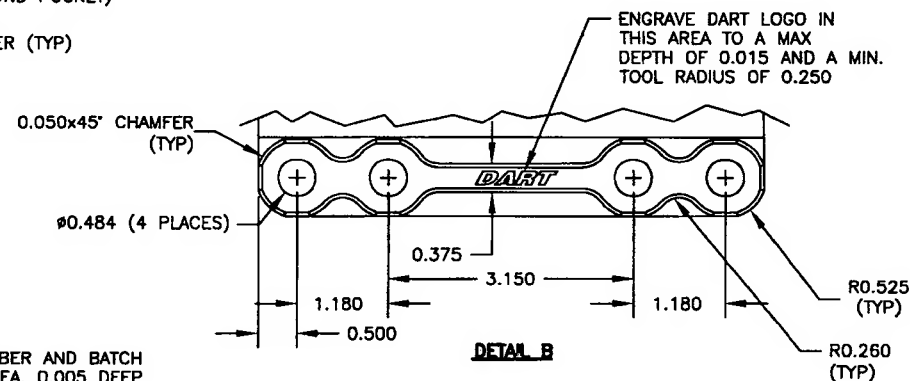
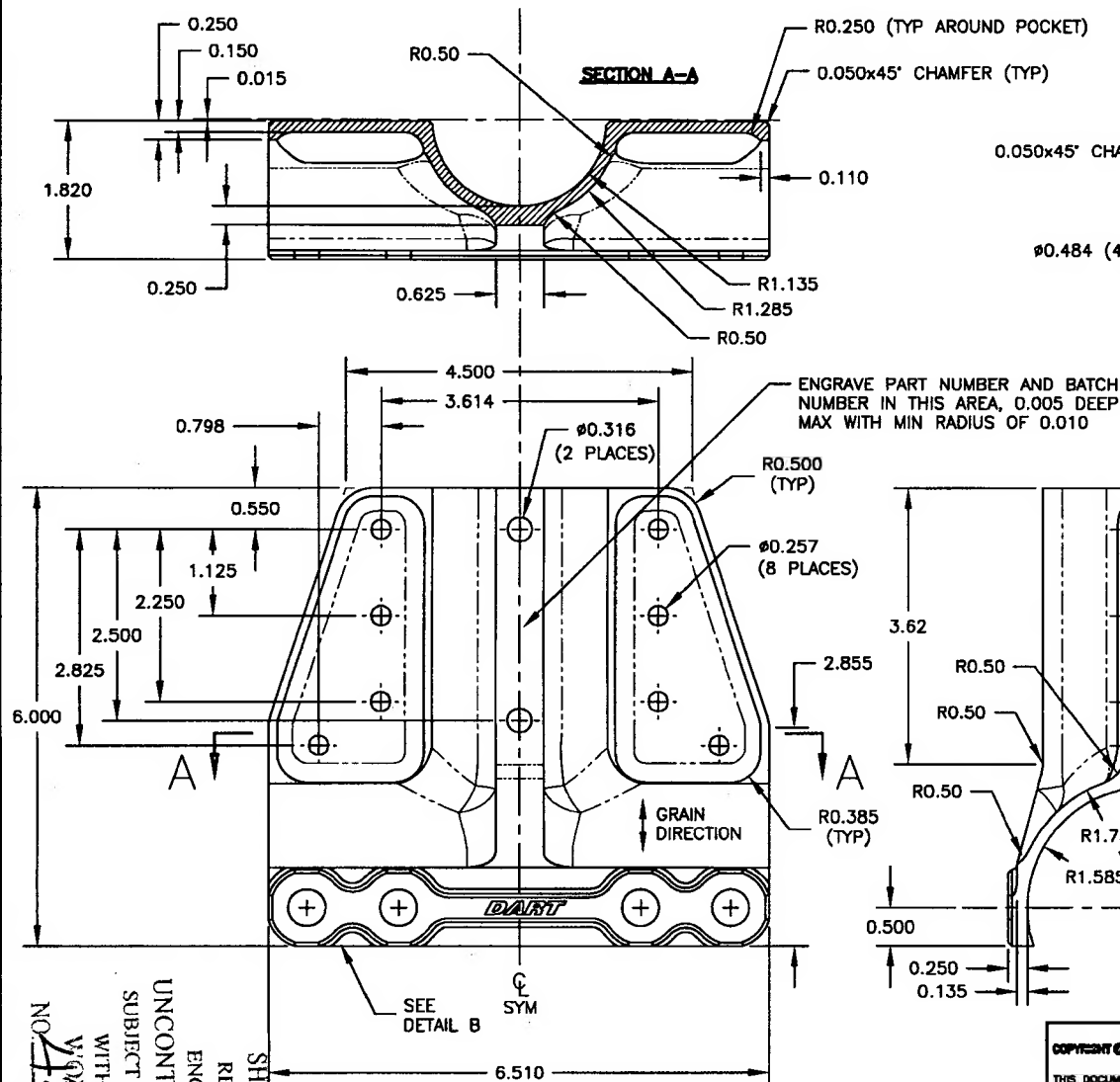
Measured by:	QML
Date:	08/11/19

Audited by:	RQ
Date:	08/11/20

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	







### D3500-1 SADDLE

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/B OR QQ-A-250/11)  
(MAKE FROM D6102-013 SADDLE BILLET, 6061)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1,  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED

06-08-15 #

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C	06.06.30	MAT'L NOW 6061-T6/T651
B	06.05.29	CHANGE DIMS; MAT'L NOW 7075-T7351
A	06.04.18	NEW ISSUE
DESIGN	97	DRAWN BY PH
CHECKED	4	APPROVED 4
DATE	06.06.30	TITLE SADDLE
DRAWING NO.	D3500	REV. C
		SHEET 1 OF 1
		SCALE 2:3

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